

Date: Wednesday, 5/3/2006 2:11:58 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE WELDMENT
Job Number : 26926	
Estimate Number : 12035	
P.O. Number : N/A	Part Number : D33551
This Issue : 5/3/2006 S.O. No. : N/A	Drawing Number : D3355 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 5/10/2006 Qty: 4 Um: Each
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	
Comment : est rev A 06.01.19 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NR1250	4130N ROUND BAR
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Comment: Qty.: 0.5250 f(s)/Unit Total: 2.1000 f(s)
 AISI 4130N ROUND BAR 1.250"dia. batch: M18490

06/05/19

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank 6.10" long

06/05/19

4

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
 1-Turn as per Dwg D3355

06/05/19

4

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 1- Mill as per dwg D3355

2-Deburr as per dwg D3355

06/05/23

4

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06/05/23

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/05/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 26926

Part Number: D33551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57428

6/4/23

(4)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP

06/05/24

(4)

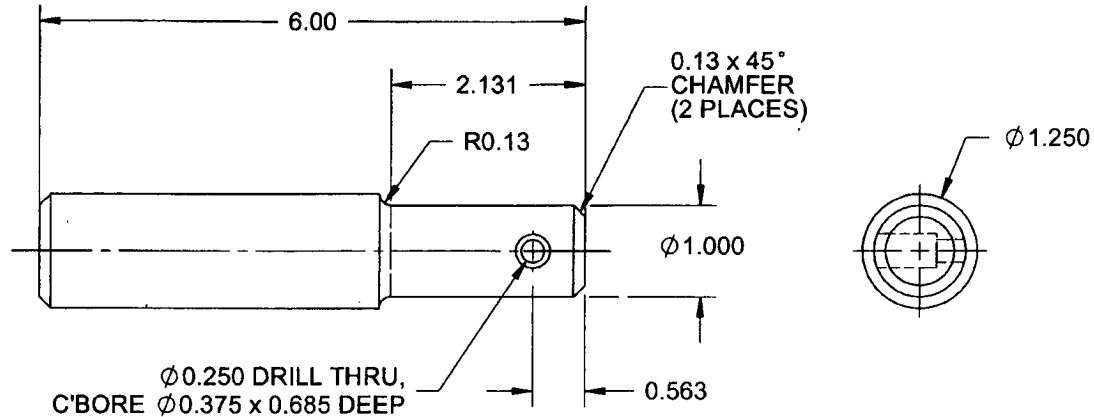
Job Completion



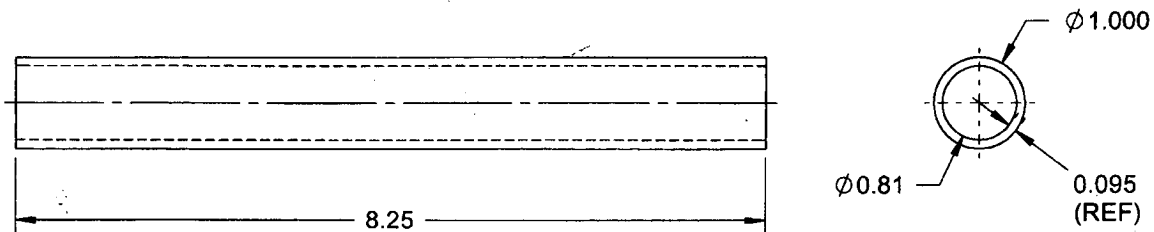
6/6/05/24

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3355	REV. A SHEET 4 OF 6
DATE 05.02.07	TITLE HANDLE WELDMENT		SCALE 1:2

RELEASED
26/03/09**D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Date: Wednesday, 5/24/2006 12:34:49 PM
 User: Chantal Lavoie

**INVENTORY ITEMS PICKED
 FOR SLIP NUMBER 2494**

Project No. : N/A
Customer : Dart Helicopters Services
Part Number : D33551
Job Number : 26926

Drawing Number : D3355 REV. A
Drawing Name : HANDLE WELDMENT
Due Date : / /
Qty : 4
Slip # : 2494

	Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0 M4130NR1250 4130N ROUND BAR							
Available 14.00	MAIN			18490		2.10	2.1000 f